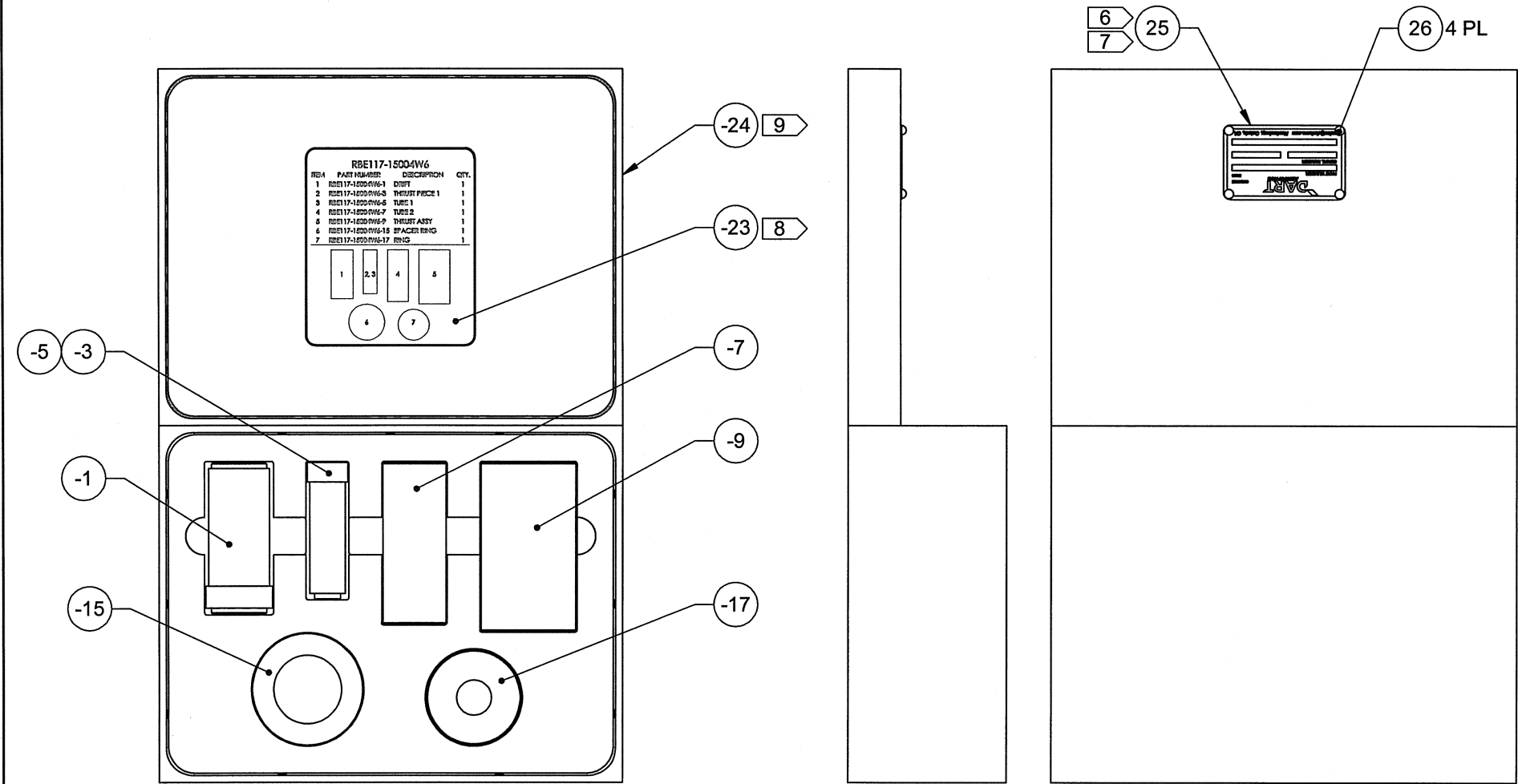


ITEM #	QTY	PART #	PART TITLE
-1	1	RBE117-15004W6-1	DRIFT
-3	1	RBE117-15004W6-3	THRUST PIECE 1
-5	1	RBE117-15004W6-5	TUBE 1
-7	1	RBE117-15004W6-7	TUBE 2
-9	1	RBE117-15004W6-9	THRUST ASSY
-15	1	RBE117-15004W6-15	SPACER RING
-17	1	RBE117-15004W6-17	RING
-23	1	RBE117-15004W6-23	CONTENT PLACARD
-24	1	RBE117-15004W6-24	PACKAGING ASSY
25	1	RB41011	DART PLACARD
26	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" LG.



NOTES:

RBE117-15004W6 PUSH OUT / PRESS IN TOOL

- 1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: ENGRAVE THE TOOL P/N ON THE DART PLACARD WHERE INDICATED
7) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINUM POP RIVETS
8) HOT GLUE THE CONTENT PLACARD ONTO THE TOP FOAM
9) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

SEE OLDEST PDF FOR PREVIOUS REVISION TEMPLATE UPDATED PER DART HBY STANDARD ITEM -1 DIMENSION $\phi 1.64$ CHANGED FOR $\phi 1.640 \pm 0.005$, HEAT TREAT 50-56 RC CHANGED FOR 48-52 Rc, FINISH ZINC PLATE CHANGED FOR BLACK OXIDE, DIMENSION .155 AND .150 CHANGED FOR 0.155 ± 0.005 2PL, DIMENSION $\phi 1.80$ CHANGED FOR $\phi 1.800$, R0.008 MAX 3 PL ADDED, DIMENSION 2X $\phi 1.487$ CHANGED FOR $\phi 1.487 \pm 0.002$ 2 PL ITEM -3 DIMENSION $\phi 1.100$ CHANGED FOR $\phi 1.100 \pm 0.002$, R0.008 MAX ADDED, CENTER DRILL ADDED, DIMENSION $\phi .698/.695$ CHANGED FOR $\phi 0.698 \pm 0.002$, FINISH ZINC PLATE CHANGED FOR BLACK OXIDE, HEAT TREAT 50-56 CHANGED FOR 48-52 Rc, MATERIAL 4140/4142 CHANGED FOR O1 ITEM -5 DIMENSION $\phi .703/.700$ CHANGED FOR $\phi 0.700 \pm 0.002/-0$, DIMENSION $\phi .96$ CHANGED FOR $\phi 0.960 \pm 0.005$, HEAT TREAT RC 50-56 CHANGED FOR 48-52 Rc, FINISH ZINC PLATE CHANGED FOR BLACK OXIDE ITEM -7 DIMENSION $\phi 1.69$ CHANGED FOR $\phi 1.690$, DIMENSION $\phi .747$ CHANGED FOR $\phi 0.747 \pm 0.005/-0$, DIMENSION $\phi 1.022 \nabla 3.34$ CHANGED FOR $\phi 1.022 \pm 0.005/-0 \nabla 3.47$, FINISH ZINC PLATE CHANGED FOR BLACK OXIDE, HEAT TREAT RC 50-56 CHANGED FOR 48-52 Rc ITEM -9 DRAWING ADDED ITEM -11 DIMENSION $\phi 1.6716/1.6700$ CHANGED FOR $\phi 1.6750/1.6740$, DIMENSION $\phi 2.56$ CHANGED FOR $\phi 2.557$, HEAT TREAT RC 50-56 CHANGED FOR 48-52 Rc, FINISH ZINC PLATE CHANGED FOR BLACK OXIDE, ITEM NAME WAS TUBE 4 IS TUBE 3 ITEM -13 DIMENSION $\phi 1.675/1.674$ CHANGED FOR $\phi 1.6758/1.6750$, R0.008 MAX 6 PL ADDED, DIMENSION $\phi .990$ CHANGED FOR $0.990 \pm 0.005/-0$, DIMENSION 2X .150 CHANGED FOR 0.150 ± 0.002 2PL, DIMENSION 2X $\phi 1.48$ CHANGED FOR $\phi 1.480 \pm 0.005$, DIMENSION .03 REMOVED, DIMENSION 0.70 3 PL REPLACE BY 0.70 2 PL ITEM -15 DIMENSION .36 CHANGED FOR 0.360, DIMENSION $\phi 1.840$ CHANGED FOR $\phi 1.840 \pm 0.005/-0$, DIMENSION $\phi 2.567$ CHANGED FOR $\phi 2.567 \pm 0.005/-0$, HEAT TREAT RC 50-56 CHANGED FOR 48-52 Rc, FINISH ZINC PLATE CHANGED FOR BLACK OXIDE ITEM -17 DIMENSION .160 CHANGED FOR 0.160 ± 0.002 , DIMENSION R0.008 MAX 2 PL ADDED, HEAT TREAT RC 50-56 CHANGED FOR 48-52 Rc, FINISH ZINC PLATE CHANGED FOR BLACK OXIDE ITEM -24 PACKAGING ASSY ADDED		19-687	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	FK	RBE117-15004W6	SHEET 1 OF 14
APPROVED	WJ	TITLE	SCALE
DATE 2019-05-31		PUSH OUT / PRESS IN TOOL	NTS
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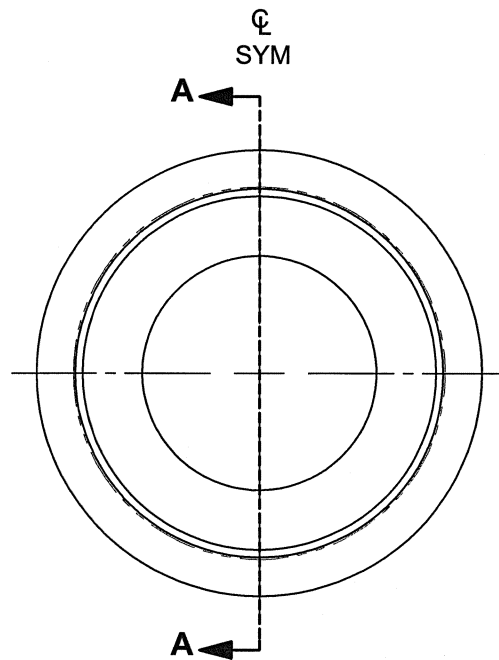
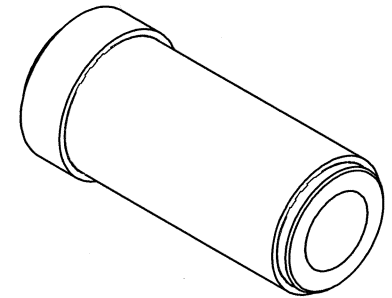
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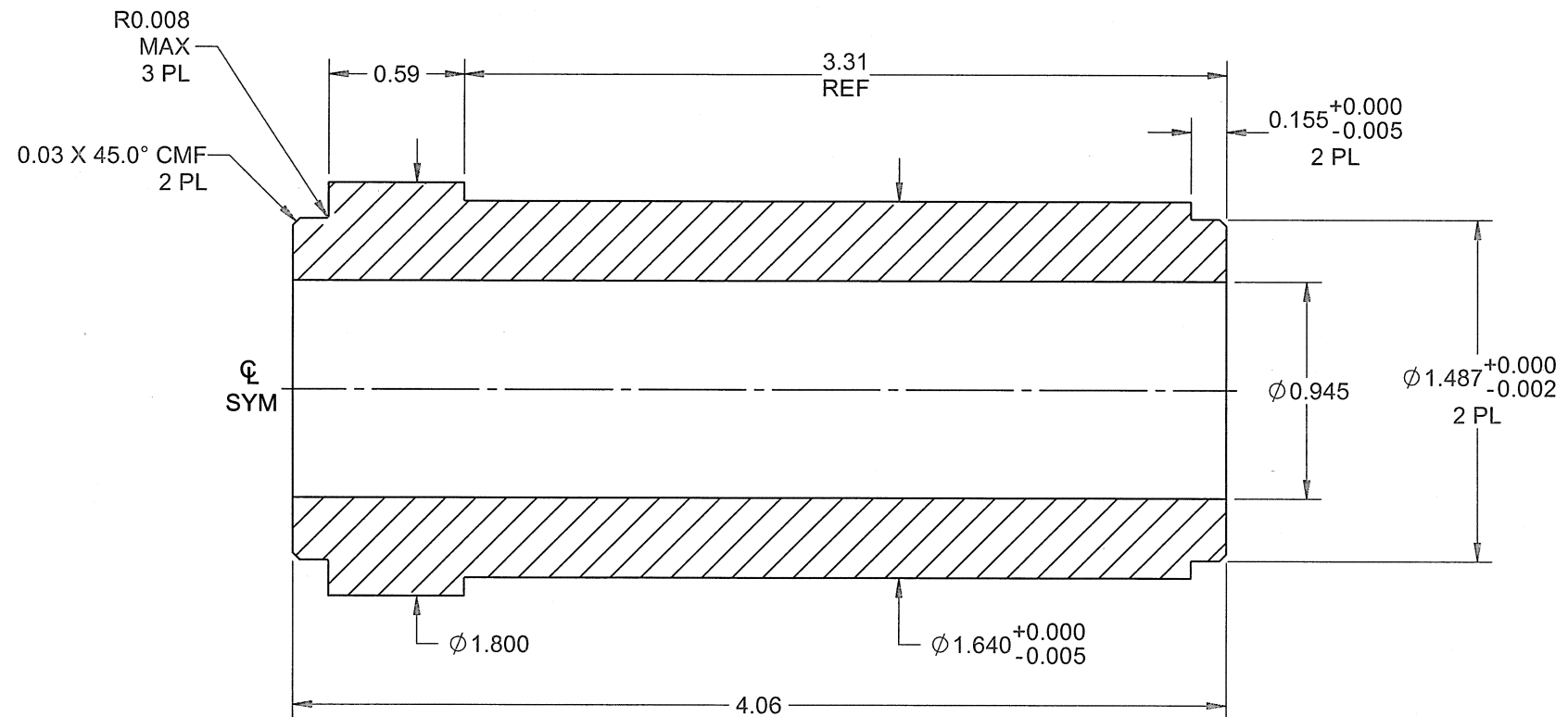
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**RBE117-15004W6-1 DRIFT**

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**SECTION A-A****NOTES:**

- 1) MATERIAL: O1
- 2) HEAT TREAT: 48-52 Rc
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005



5) UNITS: INCHES UNLESS OTHERWISE NOTED

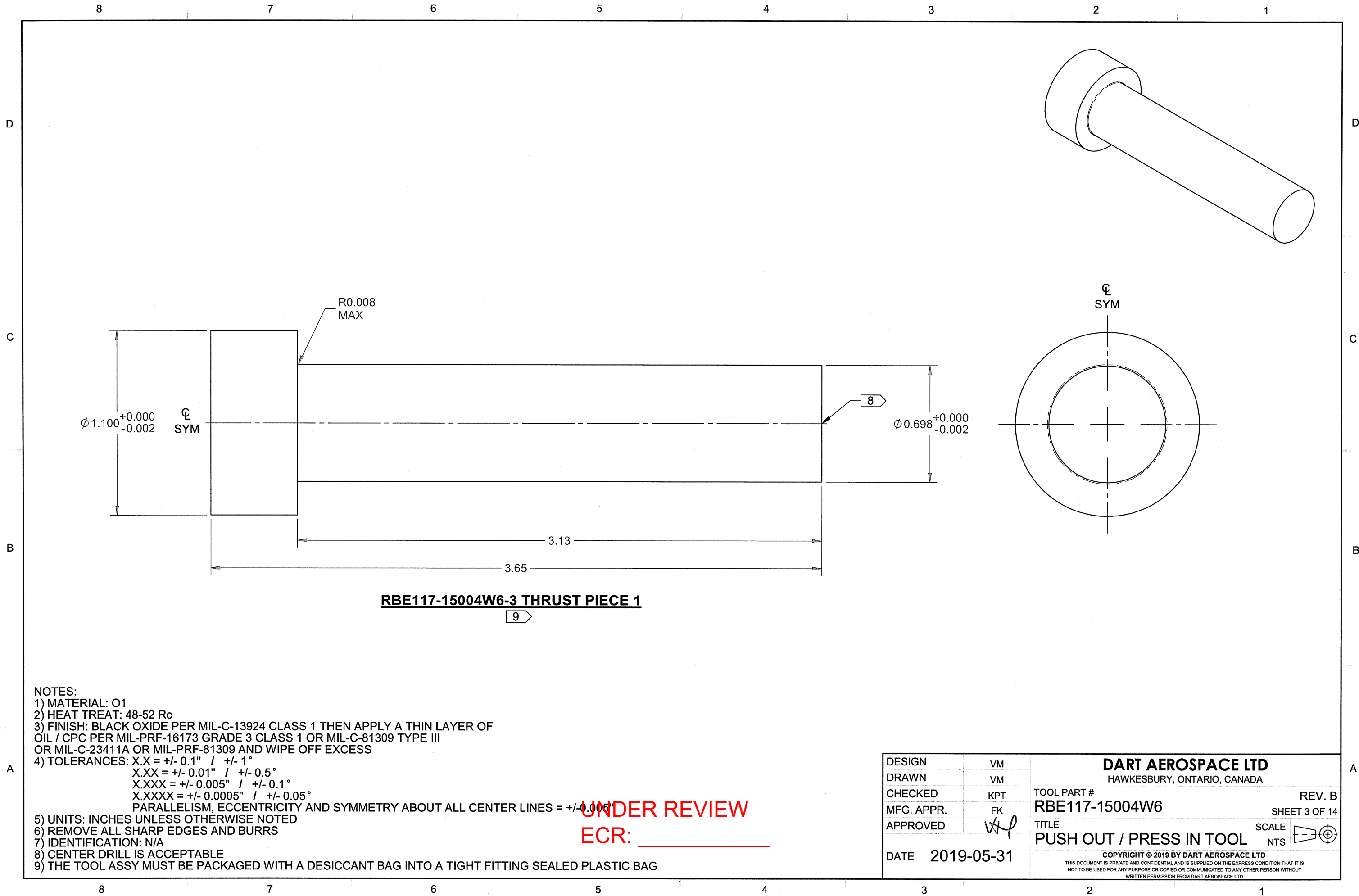
6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

UNDER REVIEW**ECR:** _____

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	FK	RBE117-15004W6	SHEET 2 OF 14
APPROVED		TITLE	SCALE
		PUSH OUT / PRESS IN TOOL	NTS 
DATE	2019-05-31	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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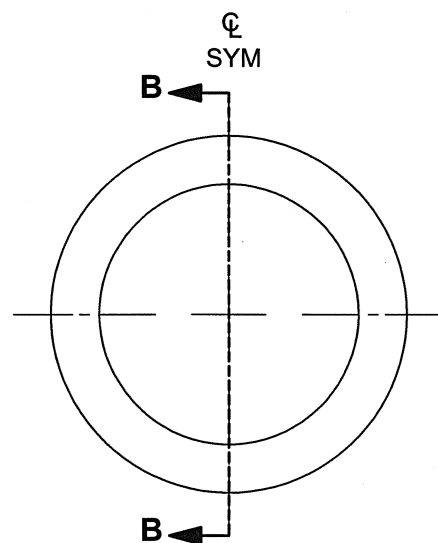
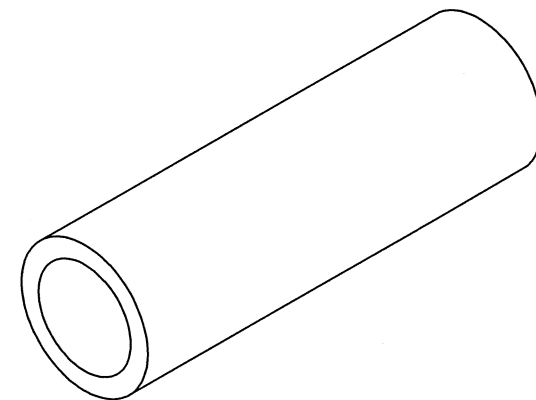
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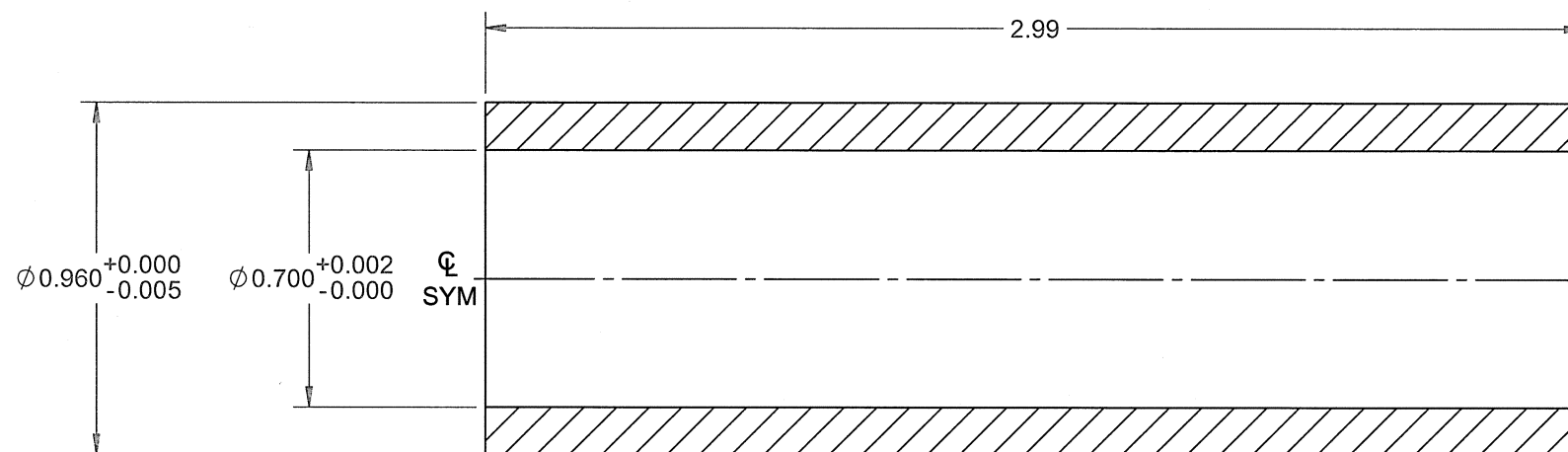
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**RBE117-15004W6-5 TUBE 1**

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**SECTION B-B****NOTES:**

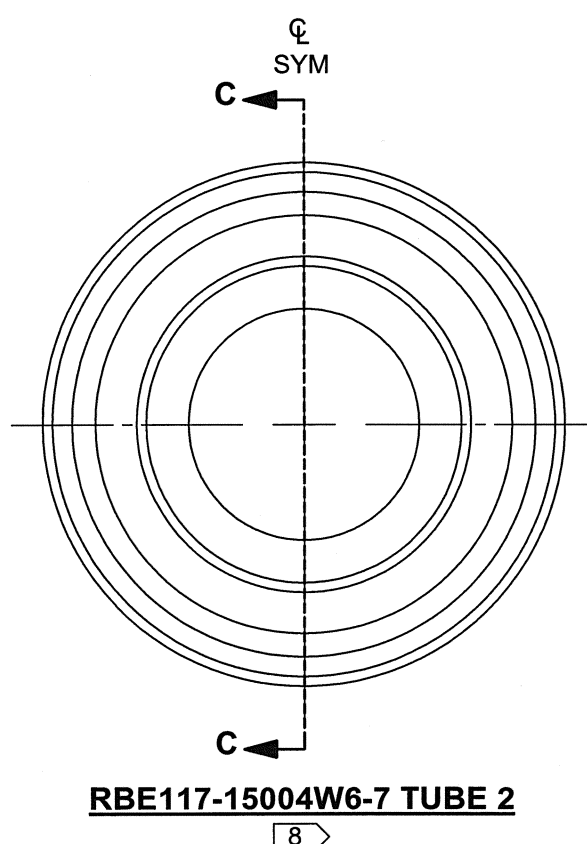
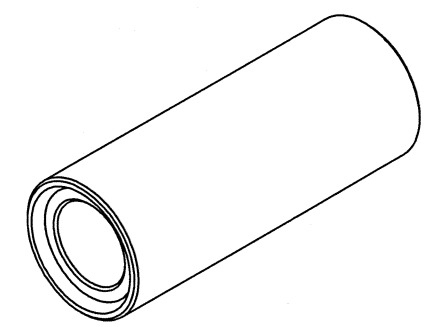
- 1) MATERIAL: O1
- 2) HEAT TREAT: 48-52 Rc
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

UNDER REVIEW
ECR: _____

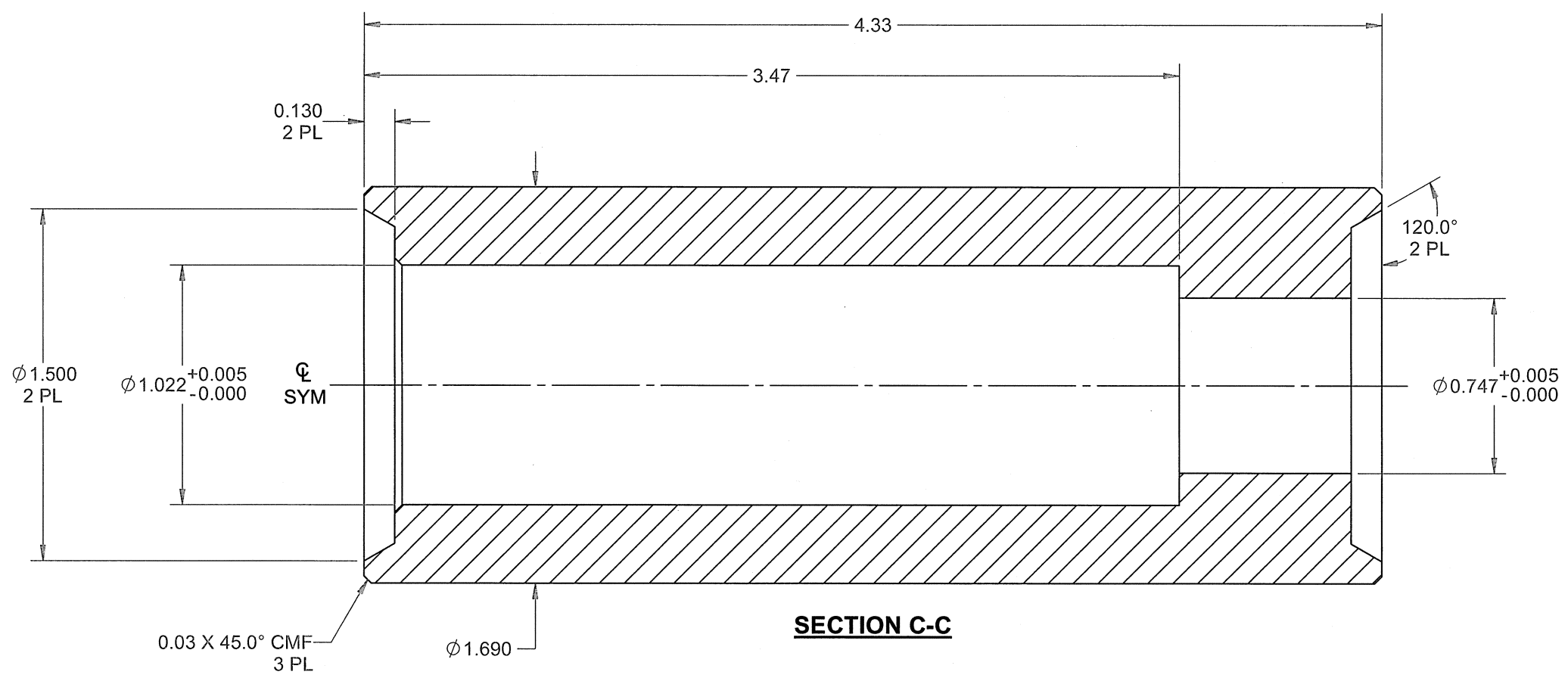
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	FK	RBE117-15004W6	SHEET 4 OF 14
APPROVED	<i>VM</i>	TITLE	SCALE
DATE	2019-05-31	PUSH OUT / PRESS IN TOOL	NTS
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RBE117-15004W6-7 TUBE 2

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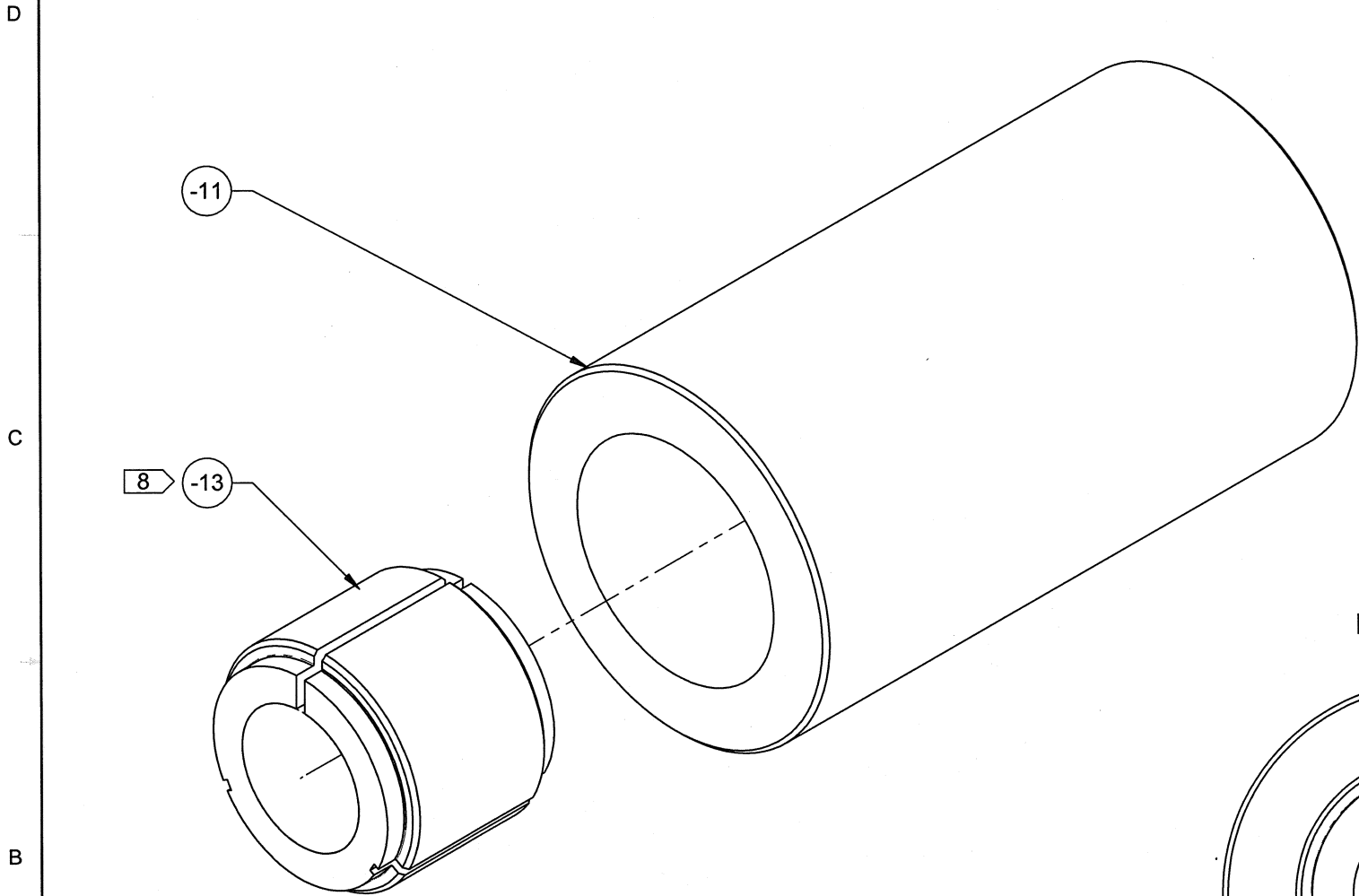


- NOTES:
- 1) MATERIAL: O1
 - 2) HEAT TREAT: 48-52 Rc
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

UNDER REVIEW
ECR: _____

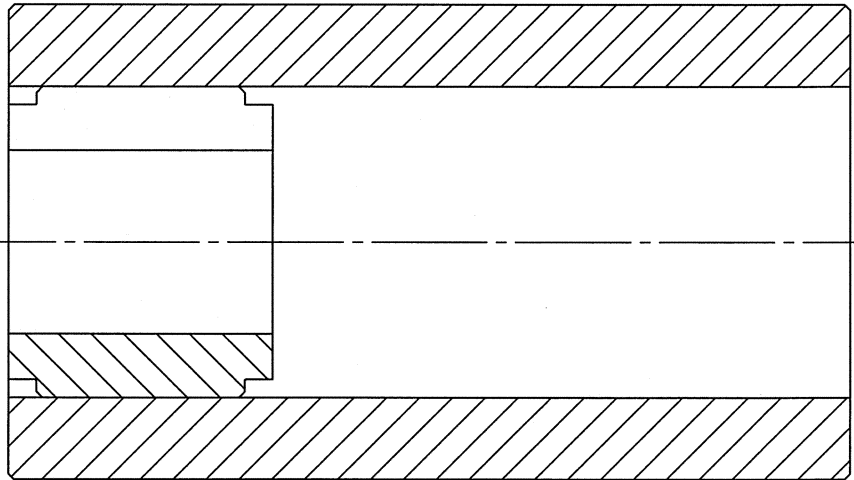
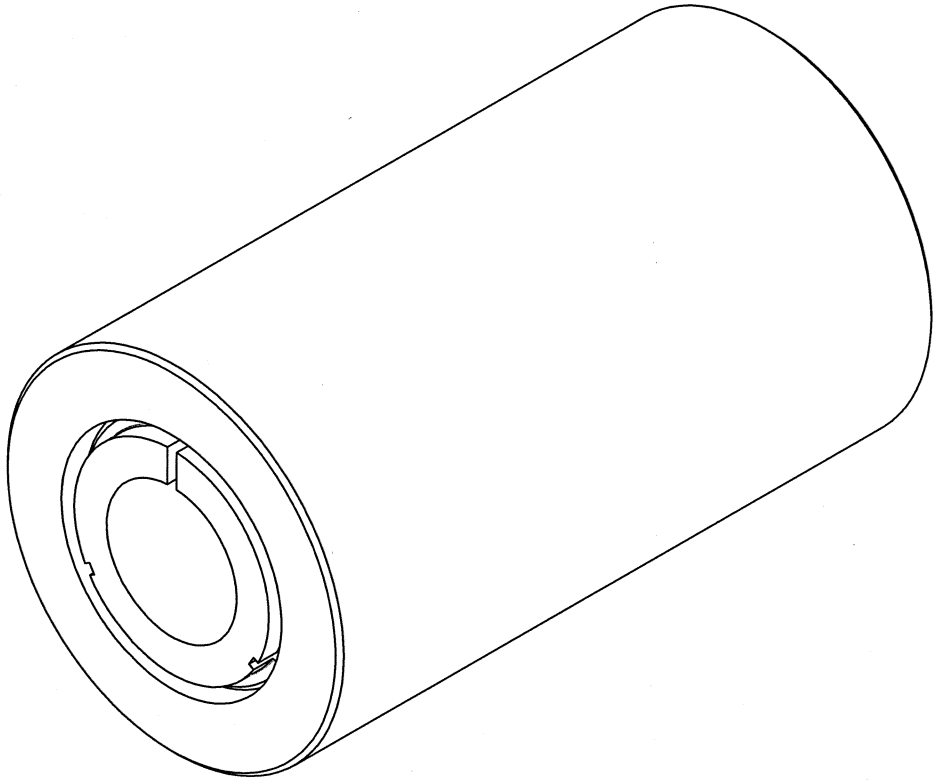
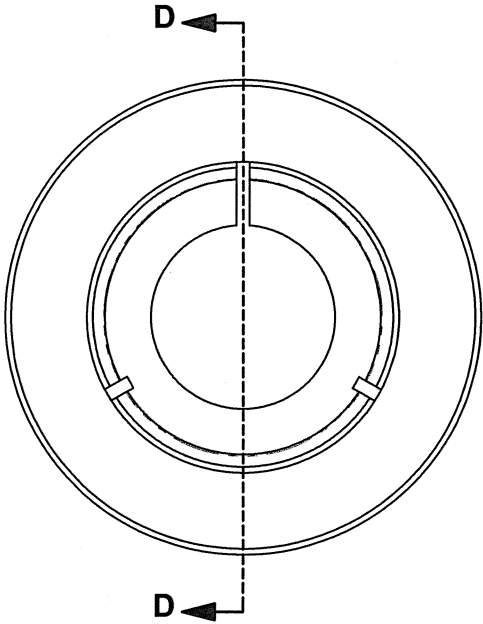
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	FK	RBE117-15004W6	SHEET 5 OF 14
APPROVED		TITLE	SCALE
		PUSH OUT / PRESS IN TOOL	NTS
DATE	2019-05-31	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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ITEM #	QTY	PART #	PART TITLE
-11	1	RBE117-15004W6-11	TUBE 3
-13	1	RBE117-15004W6-13	THRUST PIECE 2



RBE117-15004W6-9 THRUST ASSY

9



SECTION D-D

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM -13 FLUSH TO SURFACE OF ITEM -11, AND REMOVE EXCESS
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

UNDER REVIEW

ECR: _____

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	FK	RBE117-15004W6	SHEET 6 OF 14
APPROVED	W	TITLE	SCALE
		PUSH OUT / PRESS IN TOOL	NTS
DATE	2019-05-31	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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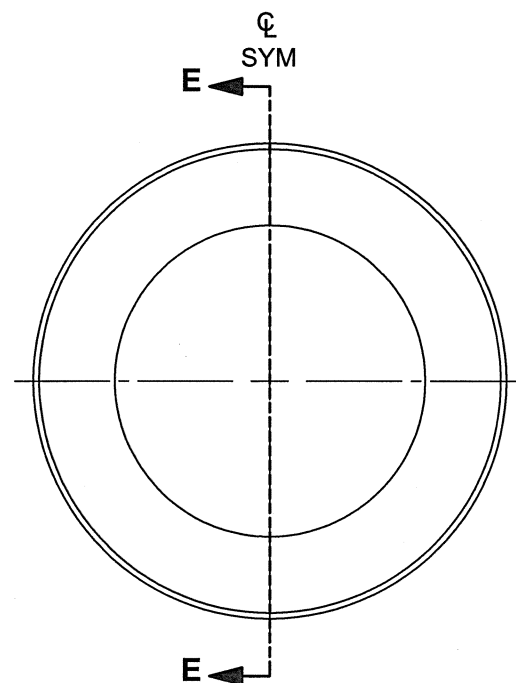
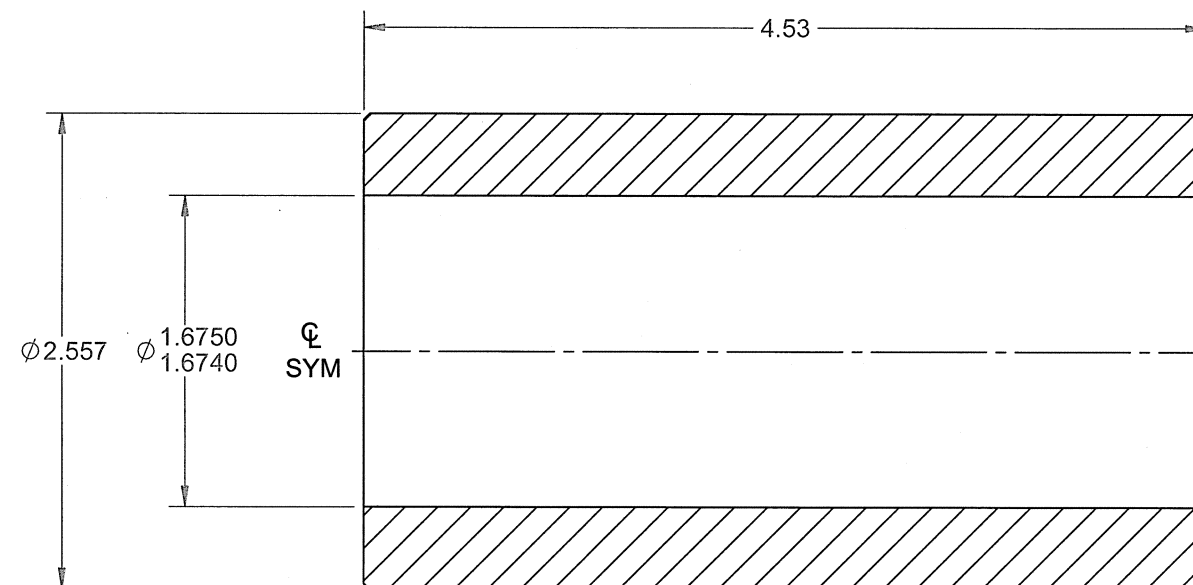
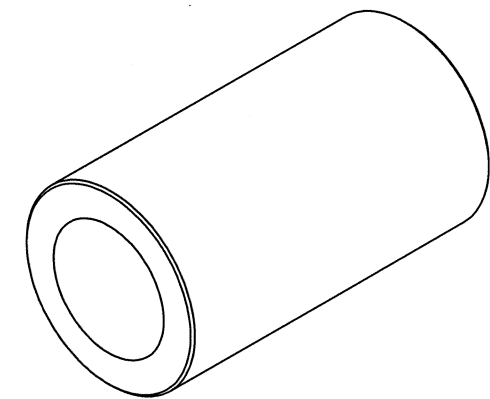
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**RBE117-15004W6-11 TUBE 3****SECTION E-E**0.03 X 45.0° CMF
2 PL

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

B

A

NOTES:

- 1) MATERIAL: O1
- 2) HEAT TREAT: 48-52 Rc
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.0005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

UNDER REVIEW**ECR:** _____

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	FK	RBE117-15004W6	SHEET 7 OF 14
APPROVED		TITLE	SCALE
		PUSH OUT / PRESS IN TOOL	NTS 
DATE	2019-05-31	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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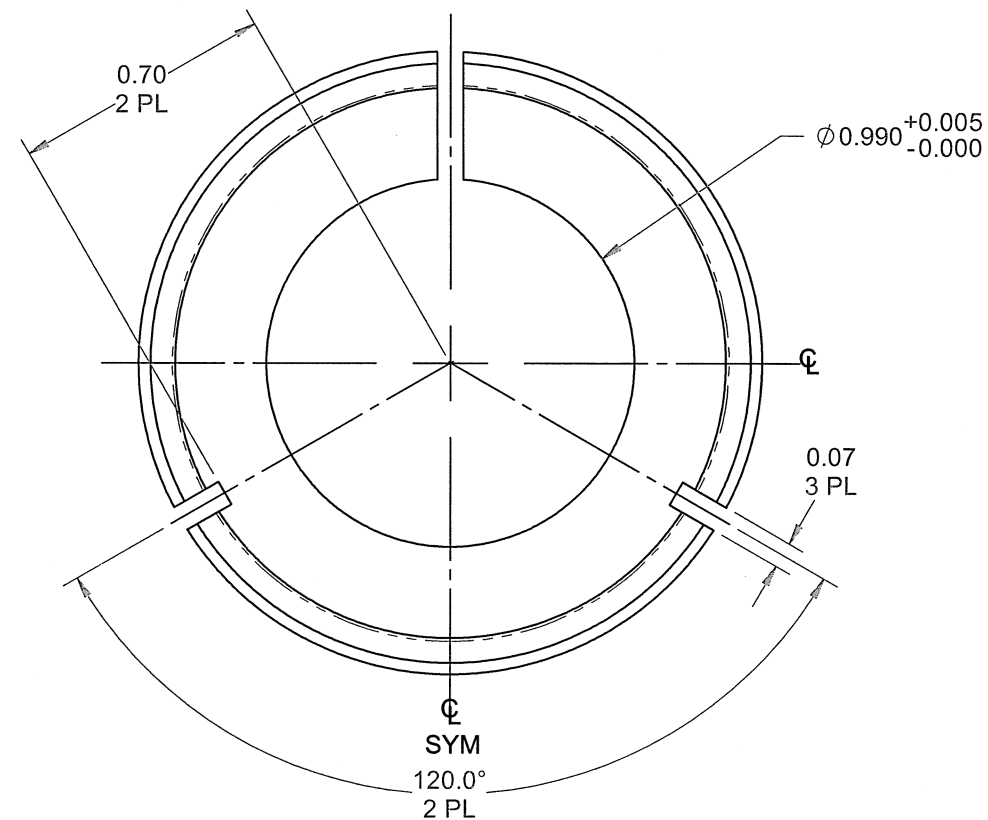
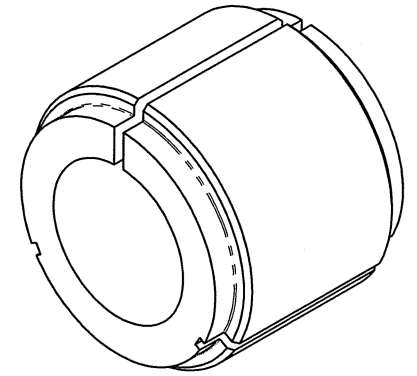
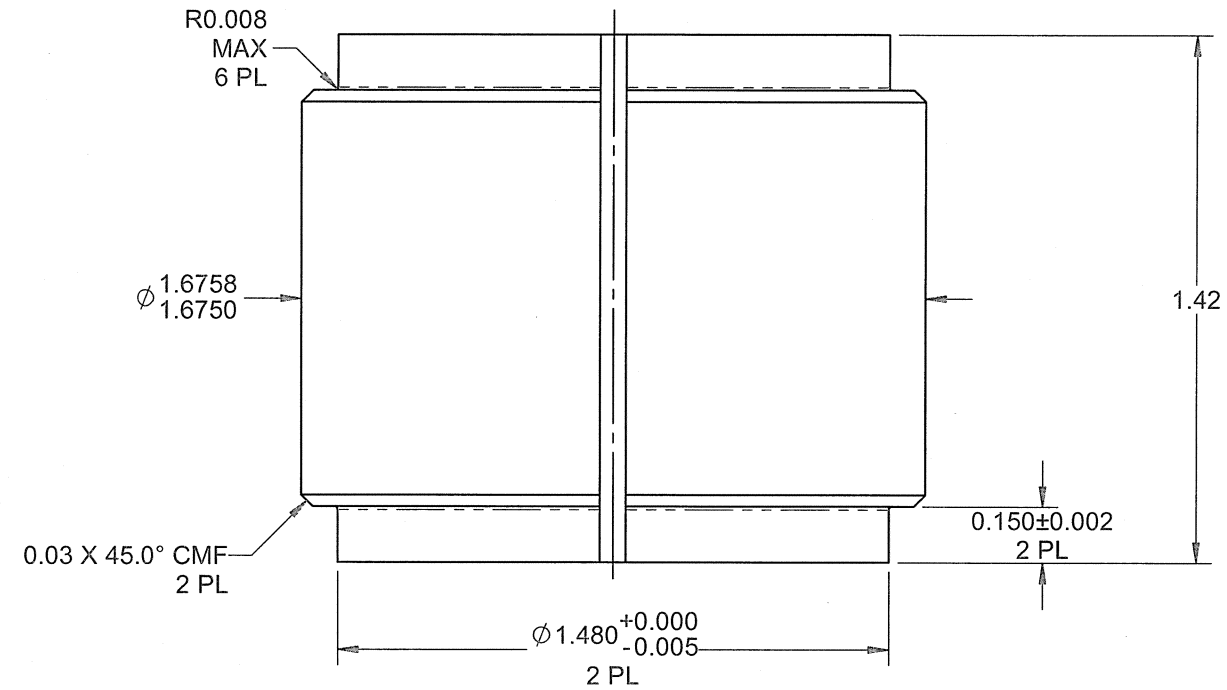
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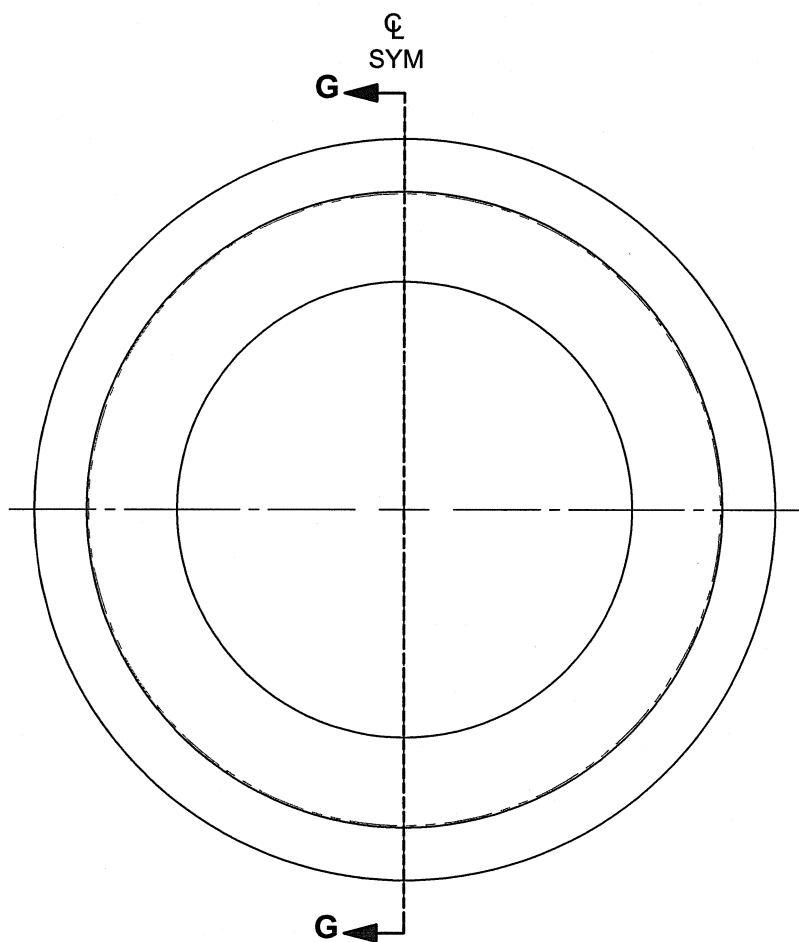


- NOTES:
- 1) MATERIAL: WHITE DELRIN / ACETAL ASTM D6100
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

RBE117-15004W6-13 THRUST PIECE 2

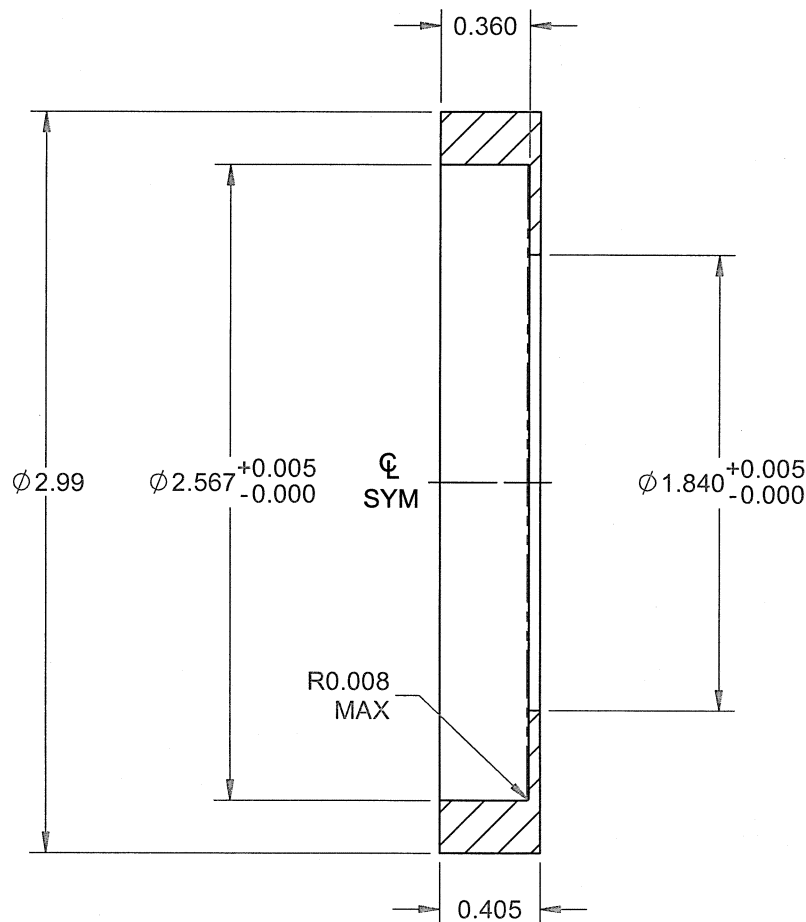
UNDER REVIEW
ECR: _____

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	FK	RBE117-15004W6	SHEET 8 OF 14
APPROVED	W	TITLE	SCALE
DATE	2019-05-31	PUSH OUT / PRESS IN TOOL	NTS
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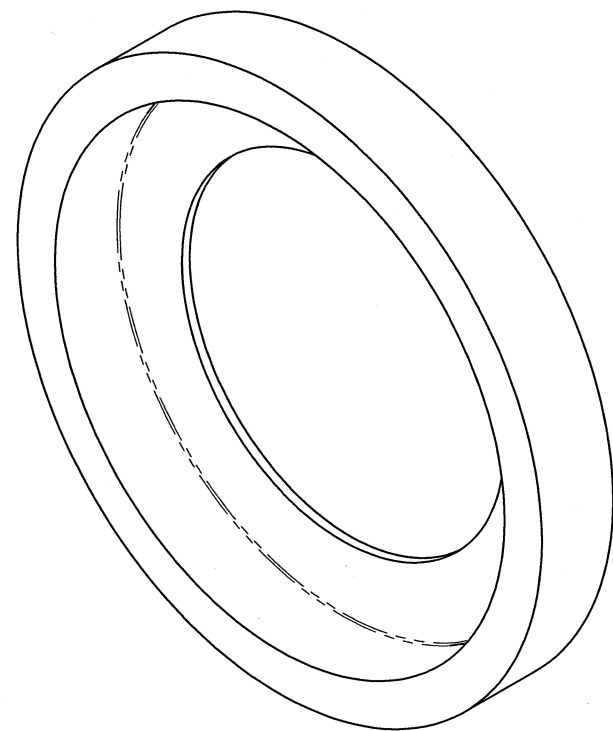


RBE117-15004W6-15 SPACER RING

8



SECTION G-G



NOTES:

- 1) MATERIAL: O1
- 2) HEAT TREAT: 48-52 Rc
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

UNDER REVIEW
ECR: _____

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	FK	RBE117-15004W6	SHEET 9 OF 14
APPROVED		TITLE	SCALE
DATE	2019-05-31	PUSH OUT / PRESS IN TOOL	NTS
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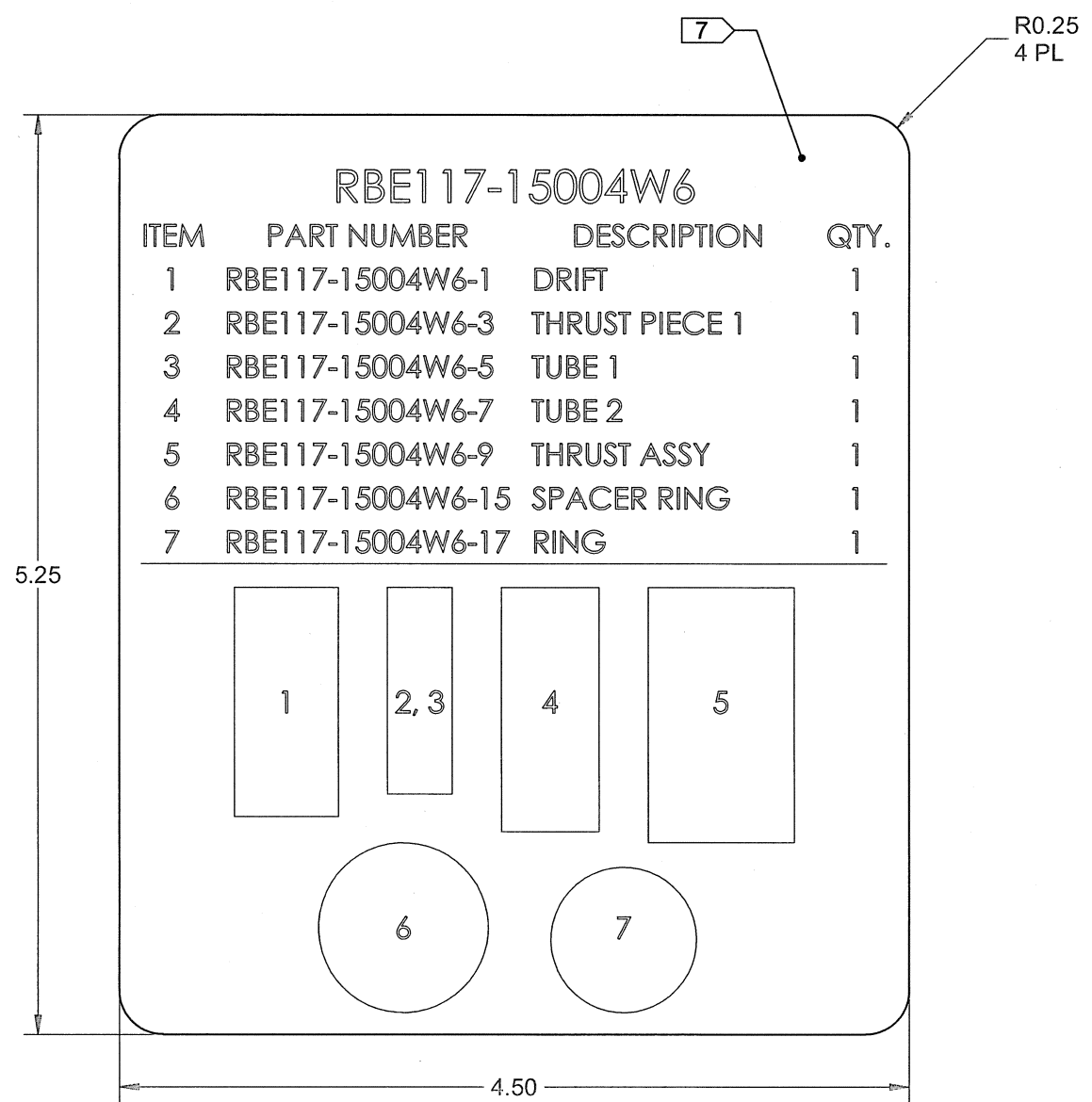
A

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RBE117-15004W6-23 CONTENT PLACARD

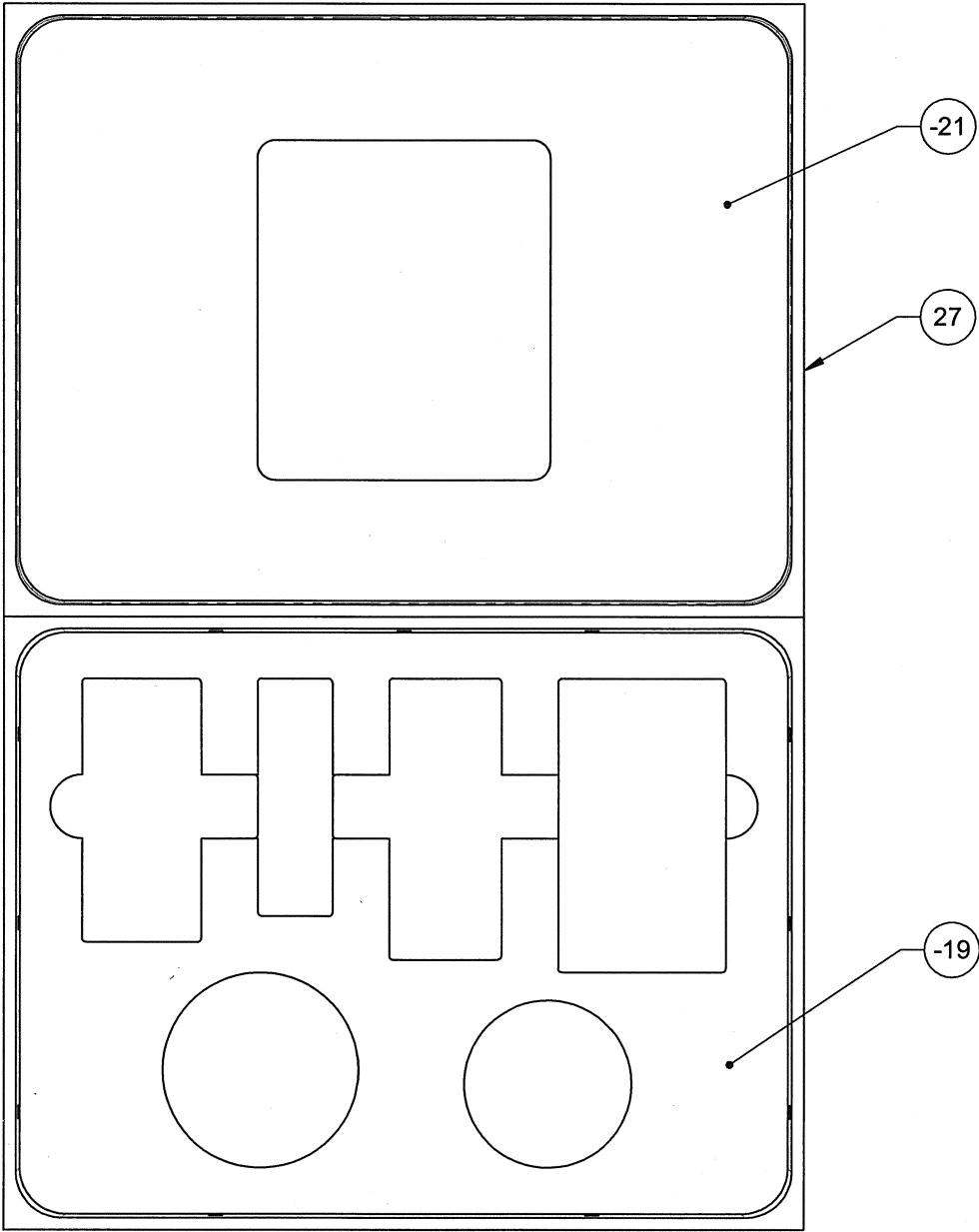
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NOTES:
1) MATERIAL: JOHNSON PLASTICS #LM922402 OR EQUIV. (BLACK/WHITE MICROSURFACED IMPACT ACRYLIC 1/16" THK.)
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) BLACK BACKGROUND WITH WHITE LETTERS AND LINES
8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBE117-15004W6-23 REV. B.DXF

UNDER REVIEW
ECR: _____

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	TOOL PART # RBE117-15004W6	REV. B SHEET 11 OF 14
DRAWN	VM			
CHECKED	KPT			
MFG. APPR.	FK			
APPROVED	<i>WY</i>			
DATE 2019-05-31		TITLE PUSH OUT / PRESS IN TOOL		
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ITEM #	QTY	PART #	PART TITLE
-19	1	RBE117-15004W6-19	BOTTOM FOAM
-21	1	RBE117-15004W6-21	TOP FOAM
27	1	PELICAN #APP-1400-E	PELICAN CASE 1400



RBE117-15004W6-24 PACKAGING ASSY

NOTES:

- 1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLE AS SHOWN

UNDER REVIEW
ECR: _____

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	FK	RBE117-15004W6	SHEET 12 OF 14
APPROVED		TITLE	SCALE
DATE	2019-05-31	PUSH OUT / PRESS IN TOOL	NTS
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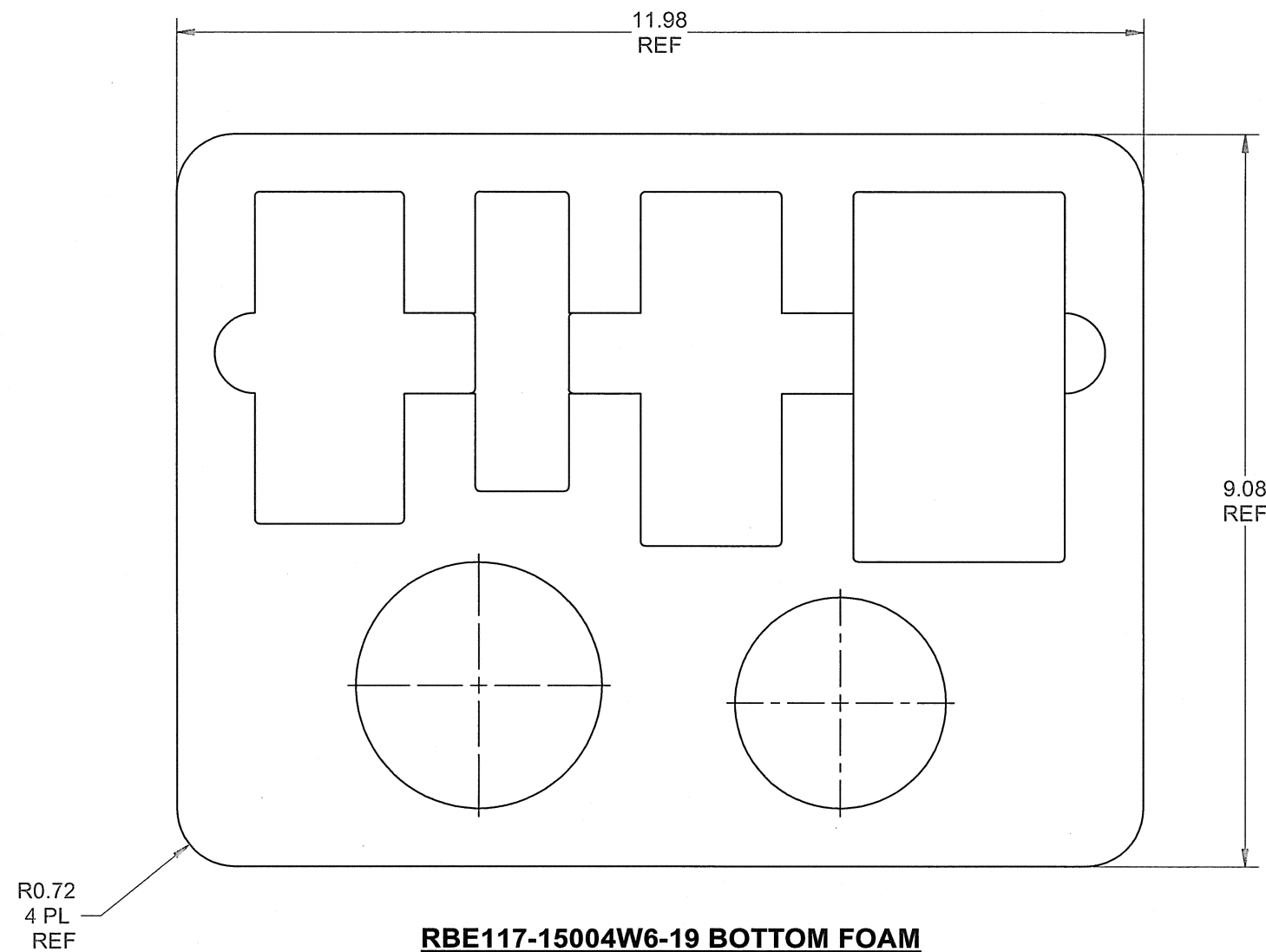
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NOTES:

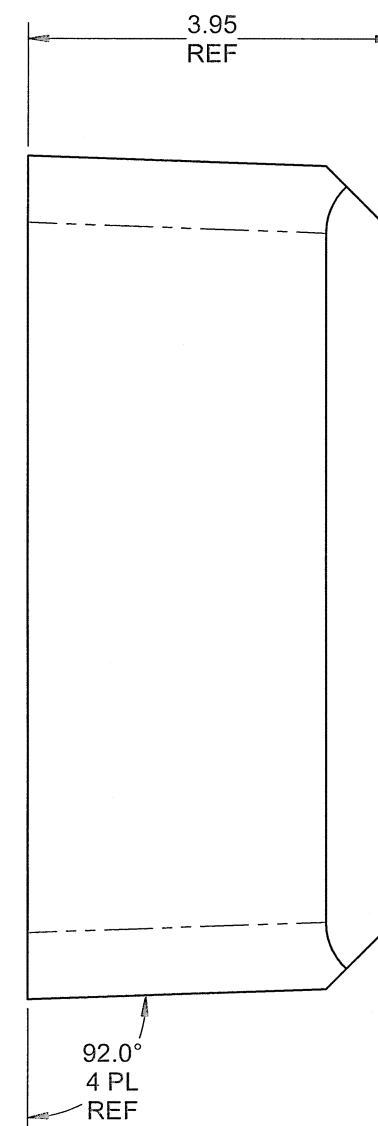
- 1) MATERIAL: BLACK ETHAFOAM 220 REF
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBE117-15004W6-19 REV. B.STEP

UNDER REVIEW

ECR: _____



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DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	FK	RBE117-15004W6	SHEET 13 OF 14
APPROVED	VM	TITLE	SCALE
		PUSH OUT / PRESS IN TOOL	NTS
DATE	2019-05-31	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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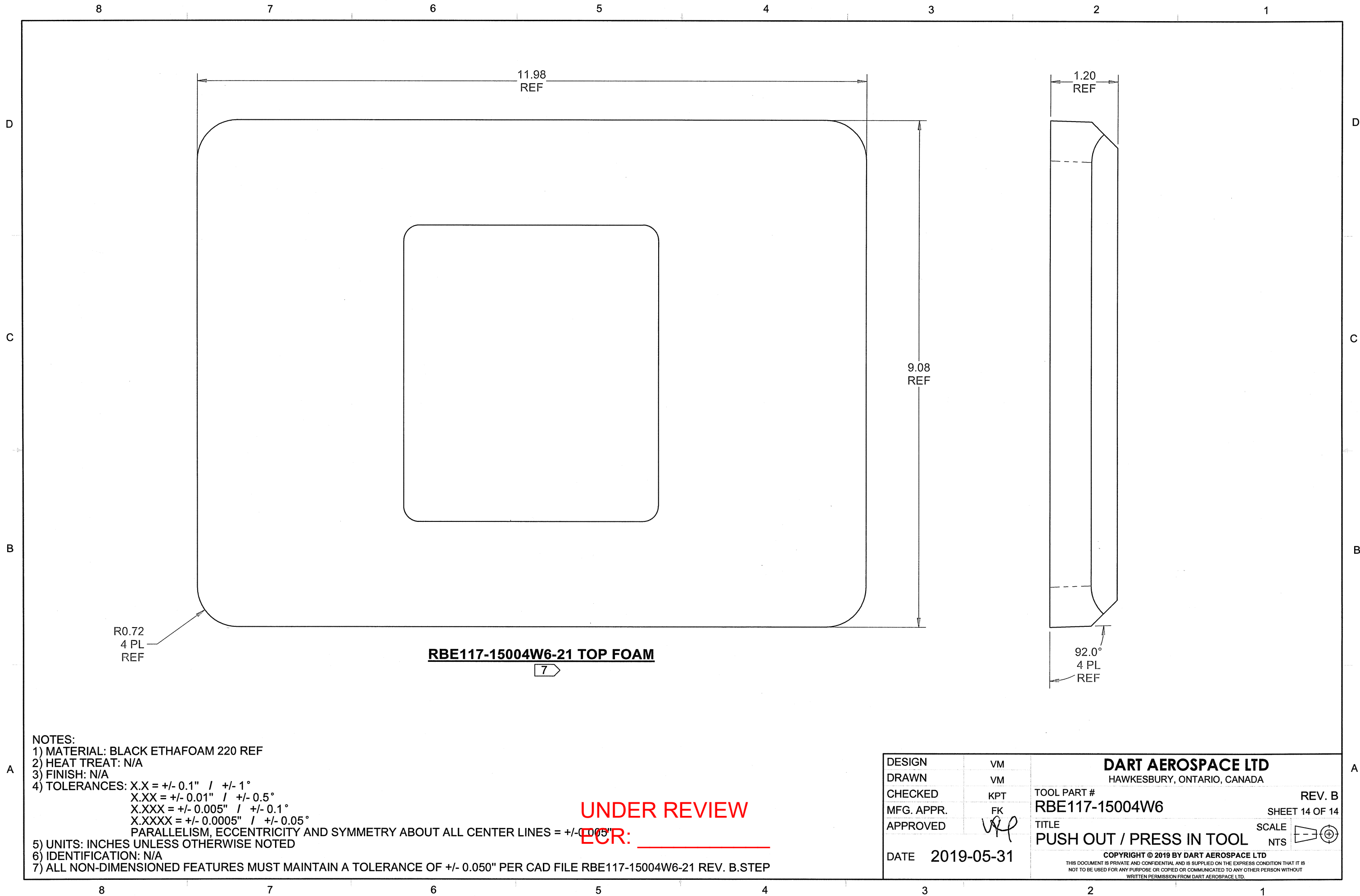
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NOTES:
1) MATERIAL: BLACK ETHAFOAM 220 REF
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBE117-15004W6-21 REV. B.STEP

UNDER REVIEW
ECR: _____

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	FK	RBE117-15004W6	SHEET 14 OF 14
APPROVED	<i>WHP</i>	TITLE	SCALE
DATE	2019-05-31	PUSH OUT / PRESS IN TOOL	NTS
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